



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3812

Job Sheet 200592



Part No: 646.3812

Job Qty: 30 pcs

Part Name: Gusset Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.3800 REV.A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD IPP REV:B 18.07.03 AS PER
DWG REV.A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	30 pcs		10/4/19	0.00	1.50	Bandsaw - 1		J.C.L.
110	Conventional Mill - 1 - B4B	30 pcs		10/4/19	0.00	4.55	Conventional Mill - 1 - B4B		J.C.L.
							Conventional Mill - 2 - B4B		
120	QC 2	30 pcs		10/4/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		J.C.L. 18-10-03
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S220084



Part: 646.3812

Job No: 200592

Serial No/Batch: S220084

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/05/19

				QC 2 - 63						
				QC 2 - 8						
				QC 2 - 66						
				QC 2 - 64						
				QC 2 - 65						
				QC 2 - 5						
				QC 2 - 71						
				QC 2 - 73						
				QC 2 - 69						
				QC 8 - 12						
				QC 8 - 14						
				QC 8 - 17						
				QC 8 - 20						
				QC 8 - 25						
				QC 8 - 3						
130 QC 8	30 pcs	10/4/19	0.00 0.00	QC 8 - 32						
				QC 8 - 33						
				QC 8 - 35						
				QC 8 - 39						
				QC 8 - 4						
				QC 8 - 44						
				QC 8 - 45						
				QC 8 - 49						
				QC 8 - 58						
				QC 8 - 8						
				QC 8 - 9						
				QC 8 - 68						
				QC 8 - 67						
				QC 8 - 1 (A)						
				QC 8 - 47						
				QC 8 - 40						
				QC 8 - 52						
				QC 8 - 23						
				QC 8 - 57						
				QC 8 - 76						
					140 Outsource - 4 - Anodize	30 pcs	10/4/19	ATG001-VC	8	08 Oct 2019 PL
				150 Packaging 2-1 - Receive - B4B	30 pcs	10/4/19	0.00 0.00	Packaging 2 - 1 - B4B		
Packaging 2 - 2 - B4B										
Packaging 2 - 3 - B4B										
Packaging 2 - 5 - B4B										
Packaging 2 - 4 - B4B										
Packaging 2 - 6 - B4B										
Packaging 2 - 7 - B4B										
Packaging 2 - 8 - B4B										
Packaging 2 - 9 - B4B										
Packaging 2 - 10 - B4B										
Packaging 2 - 11 - B4B										
Packaging 2 - 12 - B4B										
Packaging 2 - 13 - B4B										
Packaging 2 - 14 - B4B										
Packaging 2 - 15 - B4B										
Packaging 2 - 16 - B4B										
Packaging 2 - 17 - B4B										
Packaging 2 - 18 - B4B										
Packaging 2 - 19 - B4B										
Packaging 2 - 20 - B4B										
Packaging 2 - 21 - B4B										
Packaging 2 - 22 - B4B										
								Plex 9/13/19 1:14 PM Dart.lajeunesse.marie		

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[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
155 QC 6	30 pcs	10/4/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	30 pcs	10/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	30 pcs	10/4/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 100 - Bandsaw					

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9/13/2019

Descriptions: **110** - Manufacture as per dwg - 1-Machine per DWG
120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required
150 - Receive & Inspect for Damage & Mat'l Certs
180 - Identify as per dwg & Stock Location: _____ ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6A0.75X0.75X0.060X0.062	7075T6 Angle .75" X .75" X .060" X .062"W	5.4000 ft (.18 ea)	100-Bandsaw - 1	S177 700

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6A0.75X0.75X0.060X0.062	5	52	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Gusset Bracket	2.000Inches $\pm$ 0.010	2.010 1.990		
2	Gusset Bracket	0.060Inches $\pm$ 0.010	0.070 0.050		
3	Gusset Bracket	0.750Inches $\pm$ 0.010	0.760 0.740		
4	Gusset Bracket	0.060Inches $\pm$ 0.010	0.070 0.050		
5	Gusset Bracket	0.310Inches $\pm$ 0.010	0.320 0.300		
6	Gusset Bracket	0.060Inches $\pm$ 0.010	0.070 0.050		
7	Gusset Bracket	0.380Inches $\pm$ 0.010	0.390 0.370		
8	Gusset Bracket	1.250Inches $\pm$ 0.010	1.260 1.240		
9	Gusset Bracket	0.090Inches $\pm$ 0.010	0.100 0.080		

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Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

MRB (QSI042)

QTY Affected: _____

Sequence #: _____

Date: _____

Disposition

Description Work Order Deviation

Completed By

Lead hand / Supervisor

QC / QA Coordinator

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
☐	☐	☐	☐
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
☐	☐	☐	☐
Crushing	BOM/Route	Grain Direction	Drawing
☐	☐	☐	☐
Cracks	Broken/Damage/Defect	Weld	Finish
☐	☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
☐	☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence	Misread
☐	☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up	
☐	☐	☐	

Other/Details:

Root Cause

Operator	☐
Manufacturing Process	☐
Equip/Tooling	☐
Handling/Preservation	☐
Material	☐
Product Improvement	☐
Process Improvement	☐
Human Factors	☐



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044726



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044726
PO Date: 10/8/19
Due Date: 10/25/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

E-MAILED
2019-10-21

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201352	RBW109-3130-55-125	RBW109-3130-55-125 Rev 2	Pin -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X6	-	10/15/19	6 pcs	0 pcs	6 pcs	\$6.13/pcs	\$36.78
											OCT 2 2 2019	
2	199531	RBW109-3101-14-1-07	RBW109-3101-14-1 Rev 2	Bent Scissor Bar -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 - Certificate of Conformity is required	Firmed X8	-	10/15/19	8 pcs	0 pcs	8 pcs	\$6.13/pcs	\$49.04
											OCT 2 2 2019	
3	199528	RBW109-3101-14-1-01	RBW109-3101-14-1 Rev 2	Frame Top -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed X5	-	10/24/19	5 pcs	0 pcs	5 pcs	\$6.36/pcs	\$31.80
											OCT 2 2 2019	
	201193				Firmed X4	-	10/25/19	4 pcs	0 pcs	4 pcs	\$6.36/pcs	\$25.44

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PURCHASE ORDER POHB044726



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Sub Total:								9	0	9		\$57.24
4	201193	RBW109-3101-14-1-01	RBW109-3101-14-1 Rev 2	Frame Top -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Cancelled	-	10/15/19	0 pcs	0 pcs	0 pcs	\$0.01/pcs	\$0.00
5	199529	RBW109-3101-14-1-03	RBW109-3101-14-1 Rev 2	Frame Bottom -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	10/24/19	6 pcs	0 pcs	6 pcs	\$6.36/pcs	\$38.16
	201192				Firmed	-	10/25/19	4 pcs	0 pcs	4 pcs	\$6.36/pcs	\$25.44
Sub Total:								10	0	10		\$59.60
6	201192	RBW109-3101-14-1-03	RBW109-3101-14-1 Rev 2	Frame Bottom -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Cancelled	-	10/15/19	0 pcs	0 pcs	0 pcs	\$0.01/pcs	\$0.00



Dart Aerospace Ltd.
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PURCHASE ORDER **POHB044726**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	201129	RBT400352-3	RBT400352 Rev 1	Plate -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	10/15/19	7 pcs	0 pcs	7 pcs	\$6.36/pcs	\$44.52
8	199053	RBW6510G06531-6F-4	RBW6510G06531-6F Rev A	Base -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	10/15/19	7 pcs	0 pcs	7 pcs	\$6.36/pcs	\$44.52
9	199016	RBW6500G01831-3G-1	RBW6500G01831-3G Rev A	Reaction -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	10/15/19	6 pcs	0 pcs	6 pcs	\$6.36/pcs	\$38.16
10	201128	RBT400352-1	RBT400352 Rev 1	Base -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	10/15/19	7 pcs	0 pcs	7 pcs	\$6.36/pcs	\$44.52



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PURCHASE ORDER **POHB044726**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
11	201028	RB PWC70797-1	RB PWC70797 Rev 2	Plug -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	10/15/19	6 pcs	0 pcs	6 pcs	\$6.36/pcs	\$38.16
12	200592	646.3812	646.3800 Rev A	Gusset Bracket : Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	10/15/19	30 pcs	0 pcs	30 pcs	\$6.80/pcs	\$204.00
13	201160	RBT18520-16	RBT18520 Rev Q	Indicator Bracket -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	10/15/19	9 pcs	0 pcs	9 pcs	\$6.13/pcs	\$55.17

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OCT 21 2019



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PURCHASE ORDER **POHB044726**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
14	200591	646.3810	646.3800 Rev A	Bracket : Various STC's Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed X70	-	10/15/19	20 pcs	0 pcs	20 pcs	\$7.25/pcs	\$145.00
15	200994	646.3718	646.3700 Rev A	Custom Washer : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O ATG, black anodize and prime as per dwg 646.3718 Rev. A	Firmed X40	-	10/15/19	40 pcs	0 pcs	40 pcs	\$4.65/pcs	\$186.00
16	197325	D4822-1	D4822 Rev C	Upper Deflector, LH : Various STC's HARD ANODIZE IAW MIL-A-8625 TYPE 3 COLOUR BLACK PRIME AS PER DWG D4821 REV. B	Firmed	-	10/15/19	16 pcs	0 pcs	16 pcs	\$30.70/pcs	\$491.20
Grand Total:												\$1,497.91

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/21/19 10:35 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918825

Date: 24-Oct-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
		ATG Delivery
Quantity	Description	
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>OCT 24 2019</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	

Made in Canada.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Number: 918825

Pack List

Date: 24-Oct-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
30 ea	Part: 646.3812 Gusset Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot #: 9731-F-519 Job: 26222 PO: POHB044726 ✓	Rev: A Expiry Date: 06/20 Line: 12	DAS 40 9-89 OCT 28 2019
20 ea	Part: 646.3810 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# 9731-F-519 Job: 26224 PO: POHB044726 ✓	Rev: A Expiry Date: 06/20 Line: 14	OCT 28 2019
40 ea	Part: 646.3718 Custom Washer Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot# 9731-F-519 Job: 26225 PO: POHB044726 ✓	Rev: A Expiry Date: 06/20 Line: 15	OCT 28 2019 RECEIVED OCT 25 2019 DART AEROSPACE LTD.

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